110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

QC8- Inspect parts - second check

0.00

Quality Control

1311-1-2

120

QC

Quality Control

Memo

W/O:			W	ORK ORDER CI	HANGES					C
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							-			
Part No):	PAR #:	Fault Cat	egory:	N	CR: Yes	No DQ	A:	Date: _	
	R	lesolution:	Dispositi	on:		A: N/C CI	osed:	·	Date: _	
NCR:		V	WORK ORE	DER NON-CONF	ORMANO	CE (NCF	₹)			
DATE	STEP	Description of NC Section A	Section A Initial Action De			Sign 8	Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
	1		Chief Eng	Chief Eng		Date				
					,					
				,						
1	1	ì	1			1	i		1	1

Work Order ID 64791

Friday, December 17, 2010 7:55:20 AM



Page 2

Item ID:

D3246-041

Accept



Setup Start



Revision ¹D:

Item Name:

Mounting Bracket

Start Date: 12/16/2010 Required Date: 1/19/2011

Start Qty: 6.00

Reg'd Otv: 6.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Operation

Description

Date: _____ Date: _____

Tooling:

SPC (Y/N):

Set Un/

Run Hours

Date:

Date:

Tool # Plan

Code

Run

Start

Stop

Reject

Stop



Number Stamp

Sequence ID/ Work Center ID

130

Brake NC Brake NC

NC BRAKE

0.00

0.00

Deburr□Form as per Dwg D3246□C'sink as per Dwg D3246

Oty

Accept

Reject

Otv

Insp.

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

M 11/61/10

0.00

Xq

Memo

Memo

	WORK ORDER CHANGES							
STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector	
	STEP						Approval	

Part No: D3246-04 PAR #: Fault Category: Small Cab NCR: Yes No DQA: Date: 11:01-28

Resolution: Scrap QA: N/C Closed: Date: 11:01-28

NCR: 6	1791	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		* Corrective Action Section B	Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector		
Modio	130	at the set-up pale even containing to deep RC process/Locky Attation	07142	Scrop - destruey - no Rentau aty (1)	ES 10/01/10	Suloulco	05742	11/01/12		
		R.C process/LACK Attention		Q (4))						
	=									
		,								
						·				

Work Order ID 64791

Friday, December 17, 2010 7:55:20 AM



Page 3

Item ID:

D3246-041

Accept

Setup Start



Revisior ID:

Item Name:

Mounting Bracket

Start Date:

12/16/2010

Start Qty: 6.00

Required Date: 1/19/2011

Req'd Qty: 6.00



Cust Item ID: Customer:

Reference:

An	prov	als:
$\Delta \mathbf{p}$	μιυν	ais.

Process Plan:

_____ Date:

Date:_____ Tooling:

SPC (Y/N):

Date:

Date:

Start

Stop



Stop

Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

170

Small Fab

Small Fab

Small Fab

Memo

Memo

Install Nut Plates as per Dwg D3246

0.00

0.00

180

Quality Control

QC5- Inspect part completeness to step on W/O

Sulouly

	WORK ORDER CHANGES PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr Approval Chi									
DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr	٢,									
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Chief Eng /	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR	: Yes N	lo DQ	A:	Date: _	
	R	esolution:	Disposition	:	_ QA:	N/C Clo	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE	(NCR)				
DATE	CTED	Description of NC			on B	-01 0	Verifi	cation	Approval	Approval
DATE	SIEP						Sect	ion C	Chief Eng	QC Inspector
					ļ					
	-									

Work Order ID 64791

Friday, December 17, 2010 7:55:20 AM



Page 4

Item ID:

D3246-041

Accept

Setup Start

Stop



Revisior ID:

Item Name:

Mounting Bracket

Start Date:

Required Date: 1/19/2011

12/16/2010

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Qty

QC:

Date:_____

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours**

0.00

0.00

Tool ID Tool # Plan Code

Accept Qty

Reject Reject

Insp.

Number Stamp

200

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

ME (1-01-20

· · · · · · · · · · · · · · · · · · ·									
W/O:			WO	RK ORDER CHAN	GES				£ .
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	D	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	NCR: Y	es No	DQA:	Date: _	···
	Re	esolution:	Disposition	li	QA: N/0	Close	ed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORM	MANCE (N	CR)			
		Description of NC	Description of NC Corrective Action				Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section C	Chief Eng	QC Inspector
						-			
						i			
						ŀ			
			i i						
								·	

Friday, December 17, 2010 7:55:24 AM

Work Order ID: 64791

Parent Item:

D3246-041

l'arent Item Name:

Mounting Bracket



Start Date: 12 .6/2010

Required Date: 1/19/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:	PP Rev:A New Is	ssue 06-06-22	JLM										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21059L3 Nut Plate	INDIA DEL INI IEDI	Purchased	No			110	Each	54.0000	4	24 //	1/01/	/,9	
e 4				Location ST301	114718	<u>Loc</u>	54 6	Loc Code		-91	MII	658°	2 (152)
M2024T3S.050	- 	Purchased	No		116158	170	48 . sf .	92.3847	0.3097	2/ 1.956	K11-1-	,	
				Location MAT22	111381 113189	1	Qty 3847 11.89 3947	Loc Code			-		
MS20426AD3-3		Purchased	No		114968 484 4	170	80.1 5 'Each	3,847.000	8 	4894 4831		18	
	·			Location ST316	19099		Qty 3847 3847	Loc Code		7)-	- -		•

	•								
W/O:			WO	RK ORDER CHANGE	S				£
DATE	STEP	PRO	OCEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							 - 	·	·
Part No	*	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date:	
	Re	esolution:	Disposition	•	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation		Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector
					,				
					1				
									·
	1		1						

DART AEROSPACE LTD	Work Order:	441791
Description: Mounting Bracket	Part Number:	D3246-1
Inspection Dwg: D3246 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
لستسا		

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.162	عذ	ì	1B02	
Ø0.250	+0.005/-0.001	£3C.	2		U	
11.260	+/-0.010	11.267	*		PRO1802	
6.754	+/-0.010	6.758	YP		V	
5.677	+/-0.010	2674	¥		ν	
2.668	+/-0.010		4		V	
3.467	+/-0.010		¥		V	
2.750	+/-0.010	2,753	~		V	
2.370	+/-0.010	2.378	ب		ν	
0.472	+/-0.010	.412	>		ν	
0.359	+/-0.010	.358	do		V	
0.300	+/-0.010	-301	×		V	
0.301	+/-0.010	-302	سخ		1/	
					· V	
						•
		,				
	- 100					
				_		

Meas	ured by:	B	Audited by:	Prototype Approval:	N/A
	Date:	11-1-3	Date: (4 01 3	Date:	N/A
Rev	Date	Change		Revised by	Approved
Α	07.11.23	New Issue	P/O D3246-041	KJ/EC/DD	- 12

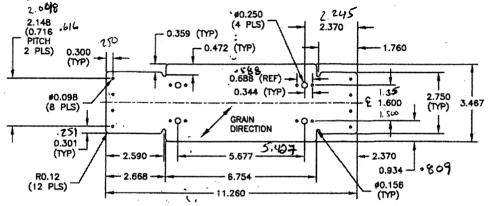
W/O:			WC	ORK ORDER CHANG	ES					
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
4					,			FTOG MIGI		
				/ / /						
					>					
Part No:		PAR #:	Fault Category: I			NCR: Yes No DQA: Date:				
					QA: N/C Closed: Date:					
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)				
DATE	STEP	Description of NC Section A	Corrective Action Section			Verification		Approval	Approval	
			Initial Chief Eng	Action Description Chief Eng	Sign Dat		Section Ç	Chief Eng	QC Inspector	
								<u> </u>		
							•			
		•								
							,			
				,	***					
				,						



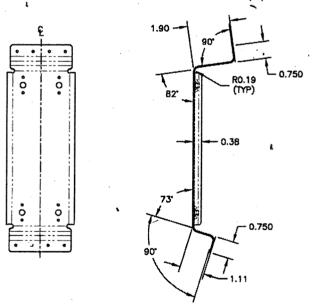


			•	-				
)	DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
	CHECKED	APPROVED	DRAWING NO.	REV. A				
	#	1 A	D3246	SHEET 1 OF 1				
	DATE		TITLE	SCALE				
	04.04.21		MOUNTING BRACKET	1:4				

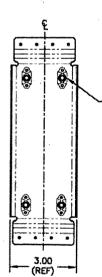
04.04.21 **NEW ISSUE** 04.06.16 CHANGE RIVET; ADDED C'SINK



D3246-1 FLAT PATTERN







D3246-041 ASSEMBLY

MS21059-L3 NUT PLATE (1) MS20470AD3-4 RIVET (2) (4 PLACES) INSTALL AFTER ALODINE €'SIMK \$0.185 × 100° MS20426AD3 3 RIVET. (2)

> SHOP COPY **RETURN TO** ENGINEERING UNCONTROLLED COP SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

NOTES:

- MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES 0.005 TO 0.010

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.